

Date: Tuesday, 3/11/2008 1:17:33 PM  
 User: Kim Johnston

## Process Sheet

12

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	CABIN DOOR ROLLER KIT, RH		
Job Number	37816	Part Number	D412698012		
Estimate Number	10289	Drawing Number	IIN D412-698 REV D		
P.O. Number		Project Number	N/A		
This Issue	3/11/2008	Type	MACHINED PARTS	Drawing Revision	D
Prsht Rev.	NC	Material			
First Issue	/ /	Due Date	3/18/2008	Qty:	2 Um: Each
Previous Run	36660				
Written By	<u>3/08 03/11</u>				
Checked & Approved By					
Comment	Est Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS Est Rev:D 08-01-28 change to rev D ECN 1104 DD				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-698-012 CHG003

08.03.14 JH

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D3121141	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

B37610 JX

Qty	Part Number	Description	Batch
3	D3121-141	Bracket Assembly	36663 4X

Batch

36663 4X

4.0	D3121144	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D3121-144	Bracket Assembly	34513

Batch

34513

5.0	D3137043	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D3137-043	Bracket Assembly	29725

Batch

29725

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 1:17:33 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN DOOR ROLLER KIT, RH

Job Number: 37816

Part Number: D412698012

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D3183044 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
1 D3183-044 Bracket Assembly 36400

7.0 D31991 Bracket



Comment: Qty.: 9.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
9 D3199-1 Bracket 37435

8.0 D32021 Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
1 D3202-1 Cover 35060

9.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-012

Location: Rev D

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf

08-04-02

V

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## 6.0 PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Part Number	Description
X							D412-698-011	CABIN DOOR ROLLER KIT, LH
	X						D412-698-012	CABIN DOOR ROLLER KIT, RH
		X					D412-698-013	DOOR HANDLE KIT
			X				D412-698-015	DOOR SUPPORT KIT
				X			D412-698-017	REPLACEMENT DOOR TRACK KIT
					X		D412-698-019	BEARING OVERHAUL KIT
						X	D412-698-021	REPLACEMENT SHIM KIT
					7		D3121-21	BOLT
					5		D3121-241	BEARING ASSEMBLY
3	3						D3121-141	BRACKET ASSEMBLY
1							D3121-143	BRACKET ASSEMBLY
	1						D3121-144	BRACKET ASSEMBLY
					1		D3137-3	GUIDE
					1		D3137-5	WASHER
1	1						D3137-043	BRACKET ASSEMBLY
					2		D3183-045	BEARING ASSEMBLY
1							D3183-043	BRACKET ASSEMBLY
	1						D3183-044	BRACKET ASSEMBLY
9	9				9		D3199-1	BRACKET
1	1				1		D3202-1	COVER
			4				D3203-1	HANDLE
			1				D3220-041	DOUBLER
			1				D3220-042	DOUBLER
			2				D3220-3	DOUBLER
				2			D3200-1	DOOR POST BLOCK
				2			D3200-3	DOOR WEDGE
				2			D3201-1	DOUBLER
				1			D3201-3	ANGLE
				1			D3201-4	ANGLE
					3		D3238-1	SHIM
					1		D3238-3	SHIM
					2		D3238-5	SHIM
					6		D3238-11	SHIM
					2		D3238-13	SHIM
					4		D3238-15	SHIM
			12				AN960JD10L	WASHER
	8						AN960JD416L	WASHER
			12				MS21042L3	NUT (OR MS21042-3)
	8						MS21042L4	NUT (OR MS21042-4)
			16				MS24694-S98	SCREW
					1		MS24694-S101	SCREW
			12				MS24693-S277	SCREW

(CONTINUED ON PAGE 15)

SHOP C/W  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 37816